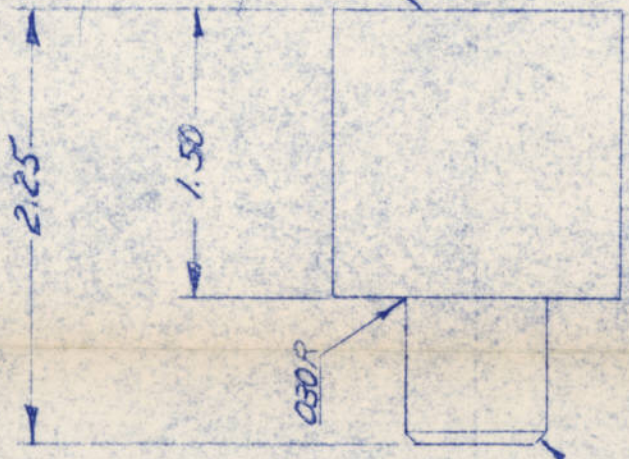


803001-1

FINISH SPECIFICATION - ARMY 3-100; NAVY SR-15

APPROVED ALTERNATE MATERIALS														
IMPORTANT: WHEN ANY OF THE FOLLOWING SUBSTITUTIONS ARE MADE, THE PART MUST BE STAMPED WITH THE SPECIFICATION OF MATERIAL USED, SUCH AS 4130, 1035, ETC.														
PART NUMBER	CHOICE	COM. SPEC.	ARMY SPEC.	NAVY SPEC.	TENSILE 1,000 P.S.I.	LOC.	LET.	FINISH						
								CODE	FINISH					
	2ND							MF	DICHROMATE PICKLE					
	3RD							NB	HOT RAW LINSEED OIL INSIDE					
	4TH							PA	ZINC CHROMATE PRIMER (1 COAT)					
									LT	ZINC CHROMATE PRIMER (2 COATS)				
									PC	ZINC CHROMATE PRIMER (2 COATS)				
									MK	CHROME DIP				
									XJ	SHOT BLAST				
									MB	CADMIUM PLATE				
									MN	ZINC PLATE				
ALTERATION														
								DATE	DRAFT	GROUP ENG.	CHECK	STRESS	WTS.	MAT. RELEASE

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STAMP, US T100308

1. USE TO SUPPORT 47-645-018-1
SHAFT DURING INSTALLATION
OF 47-645-013-4 PINION &
47-645-008-1 BEARING INNER RACE

NOTES

TOLERANCES
EXCEPT AS NOTED

ECO NO.		SHT. OF SHTS.		ABOVE ECO'S NECESSARY TO COMPLETE PRINT	
T100308		47E		47-640-044	
PART NO.		MODEL		NEXT ASSEMBLY	
REQUIREMENTS PER AIRPLANE (CONT.)		REQUIREMENTS PER AIRPLANE		REQ.	
LAYOUT NO.		SUPERSEDES		SUPERSEDED BY	
NAME OF PART		T100308		SUPPORT	
KIND		ALUMINUM BAR		245T	
STOCK		COM. SPEC.		ARMY SPEC.	
MATERIAL		NAVY SPEC.		DIA.	
THICK		WIDTH		L'GTH	
STOCK SIZE		TENSILE		1,000 P.S.I.	
DO NOT SCALE DRAWING		WORK TO DIMENSIONS ONLY		SCALE FULL	
DIMENSION LIMITS UNLESS OTHERWISE SPECIFIED		FRACTIONAL $\pm .002$ DECIMAL $\pm .001$ ANGULAR $\pm 1/2^\circ$		CAL. WT.	
BREAK ALL SHARP MACHINED CORNERS APPROX. .015 RAD. OR CHAMFER		ALL BEND RADII TO BE UNLESS OTHERWISE SPECIFIED		ACT. WT.	
SEE BELL PROCESS SPEC. 4030 FOR EXPLANATION OF FINISHES		FINISH ALL SURFACES NOT OTHERWISE SPECIFIED		ARMY	
3 SMOOTH MACHINE 3A MEDIUM MACHINE 4 ROUGH MACHINE 4 D.G. DISC GRIND		DURABLE BIDDLECOMBE		NAVY	
6/10/49		9-2-49		HEAT TREAT SPEC.	
DRAFTSMAN		GROUP ENG.		CHECK	
STRESS		WEIGHTS		PROJ. ENG.	
ENGINEER		ENG. PLAN		CUSTOMER	
BELL AIRCRAFT CORP. BUFFALO, N.Y.		SUPPORT - SHAFT		T100308	
TANK ROTOR GEAR BOX		DRAWING SIZE G		SHOW	